

SETTING OF THE CLAMPING BOLTS ON S 4.0

After any maintenance operation that may have modified the setting of the guiding cross of S 4.0 workhead, it is necessary to redo a precise setting of the guiding cross in order to avoid any degradation of the clamping bolts. Indeed, if the play is wrongly set, it can produce some shearing strains on the clamping bolts that can eventually break them up.

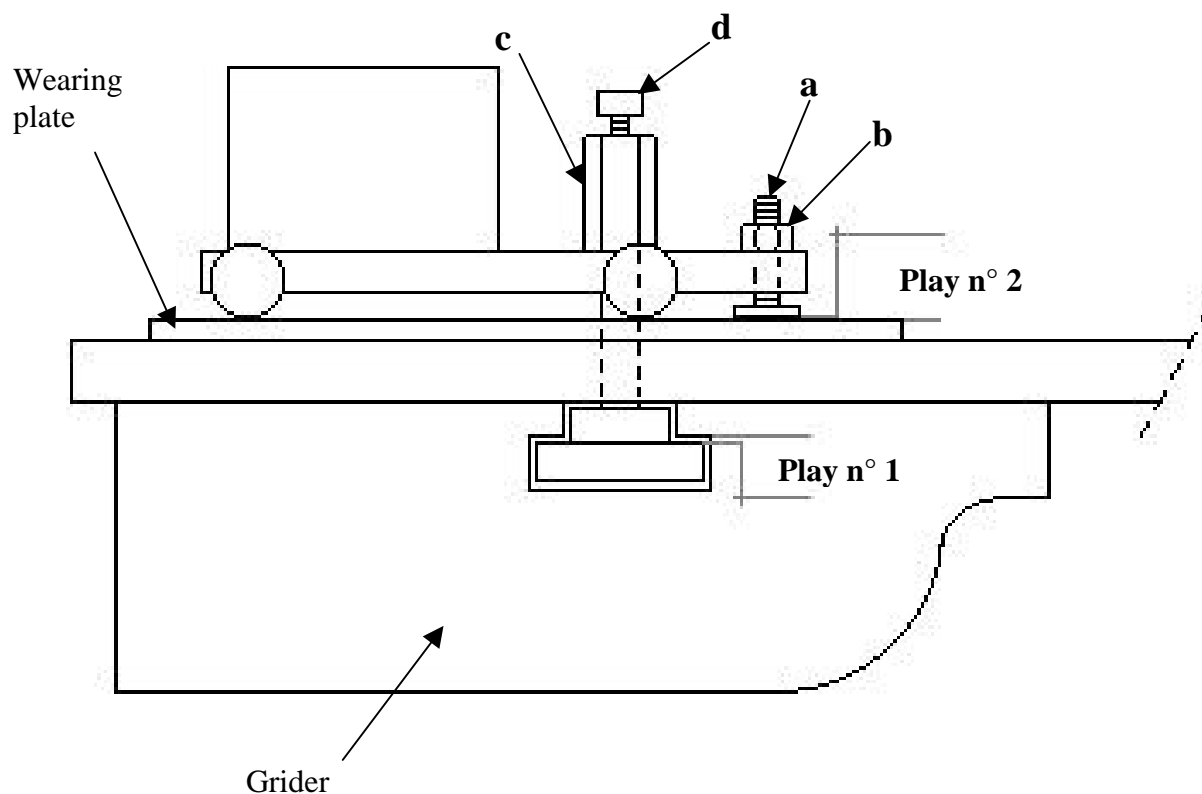
Thus, it is very important to set to their minimum the play between to guiding cross and the girder's groove (play nb 1), and the play between the screw **a** and the wearing plate (play nb 2).

IMPORTANT: This operation must be done with the machine off and the air supply shut off.

For play n°1: Tighten the setting nut **c** until the guiding cross hits the girder's groove, then loosen it of a sixth of revolution (60°) and block it with the screw **d**. This should give you a play around 0.25 mm.

For play n°2: Tighten the screw **a** until contact with the wearing plate (be careful not to lift the carriage by screwing too much). Then loosen of sixth of revolution (60°) and block it with the nut **b**. This should give you a play around 0.20 mm.

Warning: It is primordial to check that the workhead can move freely and without difficulties all along the girder and in all directions (forward – backward). If not, start over the setting where the workhead is harder to move.



Note: On the latest S 4.0 Power, the hydraulic system has been redesigned in order to help the bolts adjustment.